

Date: Thursday, 3/13/2008 10:20:24 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	SPACER		
Job Number	37930			Part Number	D30661		
Estimate Number	10383			Drawing Number	D3066 REV.B		
P.O. Number				Project Number	N/A		
This Issue	3/13/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	3/25/2008	Qty:	40
Previous Run	37878			Um:	Each		
Written By	<u>JL</u> 080313						
Checked & Approved By							
Comment	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 080 Sheet 45 Comment: Qty.: 0.0992 sf(s)/Unit Total : 3.9690 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>107276</u> X <u>21</u> = <u>2.1</u> <u>104921</u> X <u>6</u> = <u>.6</u> <u>106330</u> X <u>16</u> = <u>1.6</u> FB 8-3-24
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: <u>B</u> FB 8-3-24 Prog Rev: <u></u>
		2-Deburr if necessary FB 8-3-24
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE FB 8-3-24
4.0	QC8	SECOND CHECK J 0803-24 (43) counted
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 43 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 BL 08-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:20:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 37930

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/3/26 SIP

Comment: INSPECT CHEMICAL CONVERSION COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 231

8/3/26 SC (43x)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1008103127

Job Completion



mf

08-03-27

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37930
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

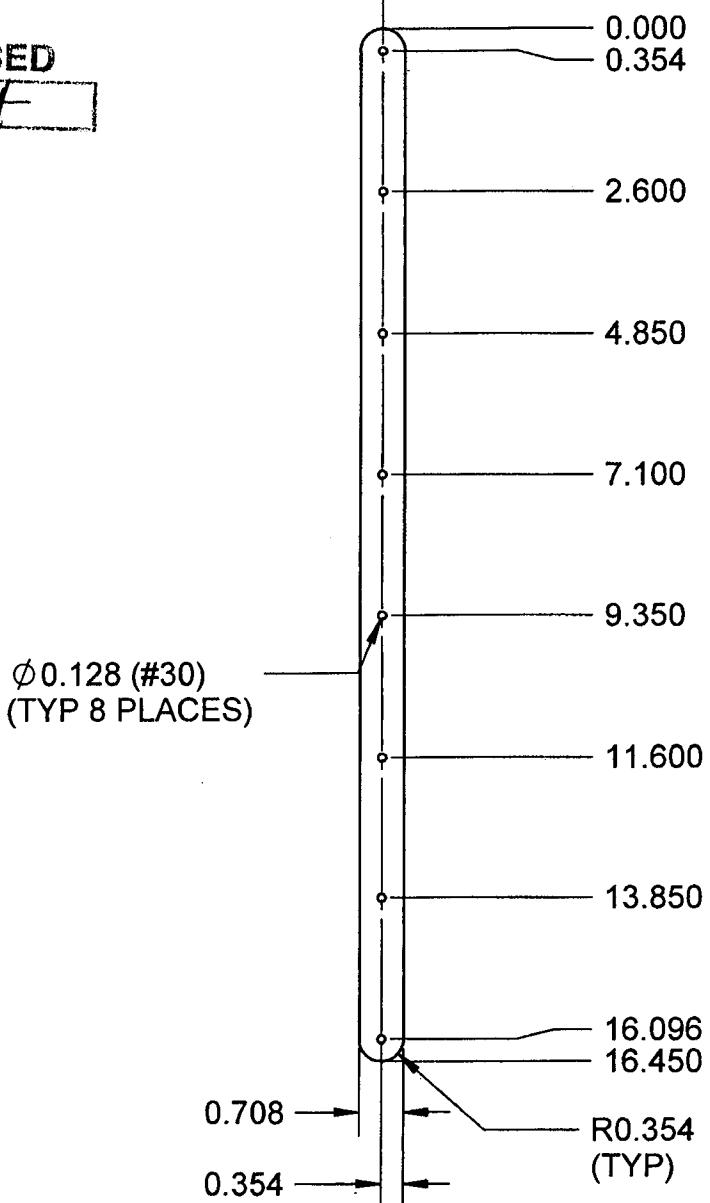
Measured by:	<u>BR</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	8-3-24	Date:	<u>7/10/24</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3066
DATE 06.05.29	TITLE SPACER	REV. B SCALE 1:3 SHEET 1 OF 1

A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

RELEASED*06.06.20 -f*

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

37930
COPY
RETURN TO
ENGINEERING
UNCOPIED COPY
SPECIAL TO AEROSPACE
W/ AEROSPACE
COPYRIGHT
NO.

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.